

Work Order ID 142341

March 07, 2016 2:33:58 PM

142341

Page 1

Item ID: D5040-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chain

Start Date: 3/7/2016

Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/21/2016

Req'd Qty: 40.00

40

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: SADate: 3/16/2016

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5040

B

110

0.00

110

Small Fab

Memo

0.05

Small Fab

Cut chain to length with Chain Break as per dwg

40 FF MAR 11 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.01

Quality Control

40DAS
38
9-89

MAR 11 2016

130

Identify as per dwg & Stock Location: 51/44

0.00

130

Packaging

Memo

0.01

Packaging

40 DAS
6
9-89

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Page 2

Item ID: D5040-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Chain

Stop *NS2*

Start Date: 3/7/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/21/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.07							
Quality Control									

MCS MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 142341

142341

Parent Item: D5040-1

D5040-1

Parent Item Name: Chain

Start Date: 3/7/2016

Required Date: 3/21/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 14.05.26 NEW ISSUE/ECN14-567 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5039-1		Manufactured	No				f	10.2600		26.32			
 *D5039-1*									**		FF	MAR 11 2016	
Chain													

Location

Loc Qty

Loc Code

ST143

142344

10.26

135676

0.13

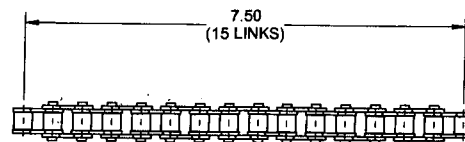
138021

0.13

139018

10

26.32



D5040-1 CHAIN

NOTES:

- 1) MATERIAL: MADE FROM D5039-1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.27 LBS
- 8) USE CHAIN BREAKER TO BREAK CHAIN TO SPECIFIED LENGTH (SEE TABLE FOR CHAIN BREAKER P/N)

CHAIN BREAKER P/N	VENDOR
1A911	ACKLANDS GRAINGER
2YEHS	ACKLANDS GRAINGER
6051K15	MCMASTER CARR

- 9) PROOF TEST EACH CHAIN TO 330# AND VERIFY THAT THERE IS NO PERMANENT DEFORMATION**

RELEASED
2014-05-26

20160307

SH 142391

B	ADD NOTE 9, ZN A8-1	VS	14.05.09
A	NEW ISSUE	AK	14.01.15
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5040	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CHAIN	NTS
DATE	14.05.09	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED